

Work Order ID 115536

Thursday, April 03, 2014 2:41:10 PM

115536

Page 1

Item ID: D412-704-041

Revision ID:

Item Name: Pedal Ass'Y

Start Date: 4/3/2014 Start Qty: 1.00 ***1***

Required Date: 4/11/2014 Req'd Qty: 1.00 ***1***

Reference: REWORK

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: MF. Date: 14-4-3

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D412-704-041

Rev B

0.00

0.00

160

160

Small Fab

Small Fab

Memo

PULL FROM STOCK D412-704-041 X 1 B56573

DISASSEMBLE & REMOVE D3205-3 AND SCRAP (OLD REV)

REMOVE AN4-12A X 2 AND DISCARD

REPLACE AND ASSEMBLE:

-D3205-3 X 1 B 97317

-D4610-5 X 1 B 108015

-AN4-11A X 2 B 128362

-NAS1149D0463J X 3 B 1127693

PER DRAWING REV B

DAS
36
9-89

1X 14/04/14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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115536

Page 2

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Revision ID:

Item Name: Pedal Ass'Y

Start Date: 4/3/2014 Start Qty: 1.00 *1*

Required Date: 4/11/2014 Req'd Qty: 1.00 *1*

Reference: REWORK

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

Quality Control

0.00

DAS
27
9-89
11/14

180

Identify as per dwg & Stock Location: _____

0.00

180

Packaging

Memo

PPP115992

Packaging

0.00

1X DAS
28
9-89 APR 14 2014

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

Quality Control

0.00

MLJ 14-04-15

MLJ 14-04-15

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Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 115536

115536

Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Ass'y

Start Date: 4/3/2014

Required Date: 4/11/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B05.01.28Removed hardware on Step 2; Added Figures 1-3KJ/RF
 IPP Rev:C06.03.08 Re-format EC
 IPP Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20 JLM
 IPP Rev:E 07.05.02 Reformat EC
 IPP Rev:F 08-10-08 as per revB DD veriified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-11A *AN4-11A* BOLT		Purchased	No				Each	316.0000		2		14/04/14	DAS 36 9-89
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					FG			20					
					120731			20					
					ST356			233					
					M128362			233		2			
					ST514			63					
					M126333			5					
					M127376			58					
D4610-5 *D4610-5* Shim		Manufactured	No				Each	1.0000		1		14/04/14	DAS 36 9-89
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST203			1					
					108085			1		1			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		
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Picklist Print

Thursday, April 03, 2014 2:41:09 PM

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Work Order ID: 115536

115536

Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Ass'Y

Start Date: 4/3/2014

Required Date: 4/11/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

Each

7,788.000

3

NAS1149D0463.J

14/04/14

DAS
36
9-89

WASHER

Location

Loc Qty

Loc Code

ST294

130

M127693

130

ST510a

7658

M127813

22

M127904

3000

M128591

4636

3

Thursday, April 03, 2014 2:41:09 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



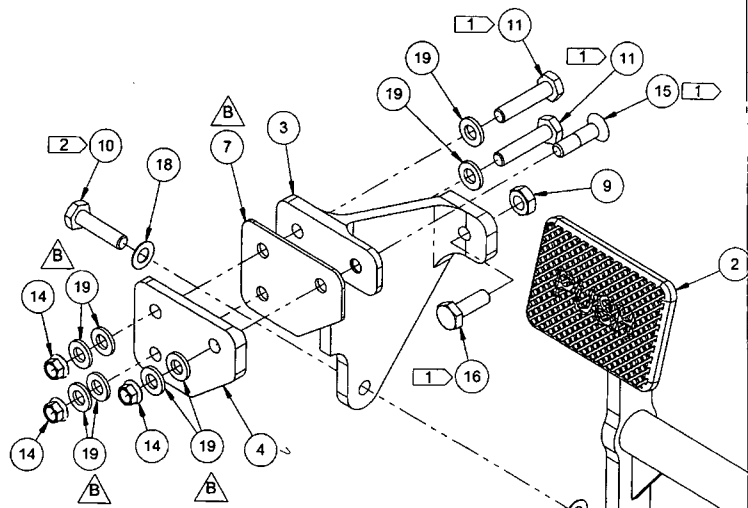
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Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
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FAULT CATEGORY			
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PARTS LIST:

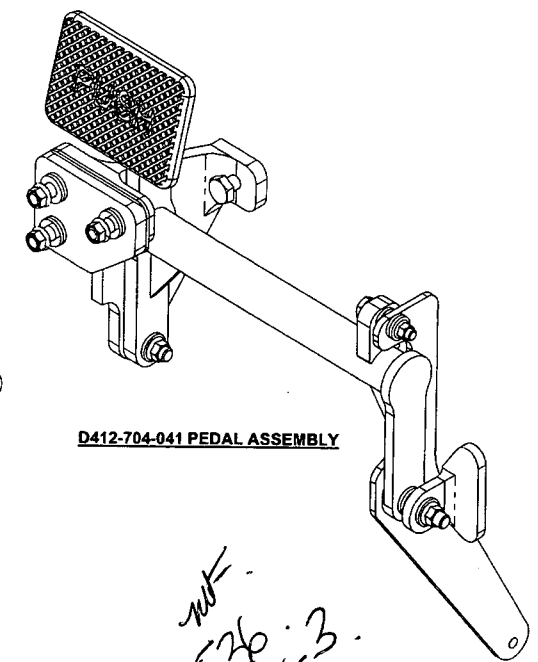
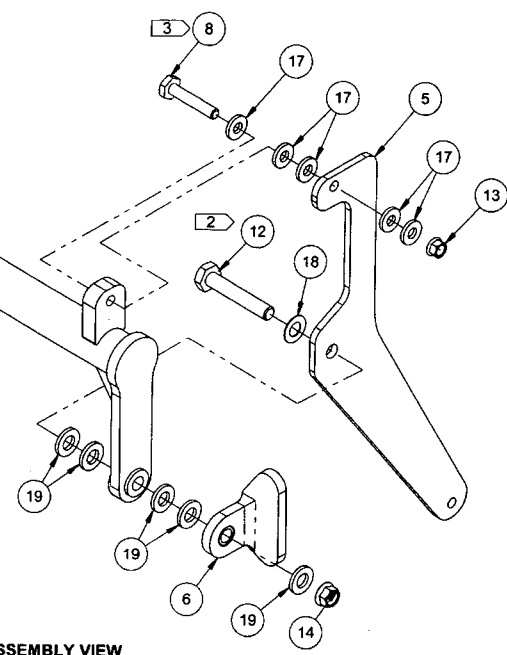
ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D412-704-041	PEDAL ASSEMBLY
2	1	D3204-041	PEDAL ASSEMBLY
3	1	D3205-1	PEDAL BRACKET
4	1	D3205-3	BACK PLATE
5	1	D3206-1	PEDAL ARM
6	1	D3209-041	BRACKET ASSEMBLY
7	1	D4610-5	SHIM
8	1	AN3-10A	BOLT
9	1	AN315-4R	NUT
10	1	AN4-10A	BOLT
11	2	AN4-11A	BOLT
12	1	AN4-13A	BOLT
13	1	MS21042L3	NUT (OR MS21042-3)
14	5	MS21042L4	NUT (OR MS21042-4)
15	1	MS24694-S102	SCREW
16	1	MS9519-10	BOLT
17	5	NAS1149D0363J	WASHER (OR AN960JD10)
18	3	NAS1149D0416J	WASHER (OR AN960JD416L)
19	14	NAS1149D0463J	WASHER (OR AN960JD416)
N/A*	2	AN3-6A	BOLT
N/A**	4	NAS1149D0332J	WASHER (OR AN960JD10L)
N/A*	2	MS21042L3	NUT (OR MS21042-3)

EXPLODED ASSEMBLY VIEW

NOTES:

- 1) INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
- 2) TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG. ENSURE THAT PARTS CAN STILL ROTATE.
- 3) TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).

* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)



D412-704-041 PEDAL ASSEMBLY

WLF
* 115536
14-4-3

RELEASED
2012-03-21
PER ECN 12-545 CP

B	ADD D4610-5 (ZN D8-1); ADD WASHER (ZN A8-1, B6-1, C8-1, D8-1); AN4-11A WAS AN4-12A (ZN B6-1)	RF	12.02.24
A	NEW ISSUE	CB	07.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN	C.B.		
DRAWN	RF		
CHECKED	ED		
MFG-APPR	ED		
APPROVED	ED		
DATE	12.02.24		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D412-704-041 TITLE PEDAL ASSEMBLY REV. B SHEET 1 OF 1 SCALE COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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